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CLAIMS

1.
 a ~~(1)~~ An exhaust device for internal combustion engines
 a having a pipe element ~~(1)~~ inside which there flow the
 a exhaust gases, the said pipe element ~~(1)~~ having a housing
 a ~~(2)~~ in which a measuring transducer such as an oxygen
 a sensor can be mounted, characterized in that the said
 a housing ~~(2)~~ is formed by a hole prolonged by a bush ~~(3)~~
 a made directly through the wall of the said pipe element
 a ~~(1)~~, the said housing ~~(2)~~ being obtained from a first
 flow-drilling operation followed by a second operation of
 thread tapping by deformation, the said flow-drilling
 operation comprising drilling through the wall with a
 tool, a speed and a penetration force adapted to cause
 melting and upsetting of the material around the tool in
 proportion to the advance of this tool, until a bush of
 required height and diameter is obtained.
2.
 a ~~(2)~~ An exhaust device for internal combustion engines
 according to claim 1, characterized in that the said pipe
 a element ~~(1)~~ is provided with a wall of substantially
 uniform thickness of between 1 and 3 mm.
3.
 a ~~(3)~~ An exhaust device for internal combustion engines
 according to ^{claim 1} ~~any one of claims 1 to 2~~, characterized in
 a that the said pipe element ~~(1)~~ is provided with a wall
 made of stainless metal alloy.

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a 4. ,
a 141 A process for making an exhaust device according to
claim 1, ~~any one of claims 1 to 3~~, characterized in that the said
tool comprises an ogival mandrel.

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